

Work Order ID 77848

Thursday, December 22, 2011 8:04:29 AM

77848

~~PRELIMINARY ISSUE~~

Page 1

Item ID: D4571-3

Accept

N9000040100

Setup Start

NS1

Revision ID: ~~PRELIM~~

Stop

NS2

Item Name: Cover



Start Date: 12/23/2011 Start Qty: 3.00

3

Cust Item ID:

Required Date: 12/29/2011 Req'd Qty: 3.00

3

Customer:

Reference:

11.12.22

Run Start

NR1

Approvals:

Process Plan:

Date:

Tooling:

Date:

Stop

NR2

QC:

Date:

SPC (Y/N):

Date:

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4571

PAT

A

12.01.16

100

Cut blanks as per folio

0.00

100

Bandsaw

Memo

0.00

Jeaspa Bandsaw

CUT TO 7.250" LONG

36/ba

11/2/28 7

105

0.00

105

HAAS 1

Hardinge CNC LATHE SMALL

Memo

0.00

HAAS CNC vertical machine #1

MACHINE AS PER FOLIO FB081 AND DWG D4471

FOLIO REV: *AA*

DWG REV: *PA*

DEBURR

36/ba

11/2/28 7

\$ Pro ->
Let Pro

77848

Thursday, December 22, 2011 8:04:29 AM

N900040100

Setup Start *NS1*

Stop *NS2*

3

Cust Item ID:

3

Customer:

Reference:

Run Start *NR1*

Stop *NR2*

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

**Insp.
Stamp**

0.00

SL 12-01-04

110

QC

Memo

0.00

Quality Control

0.00

on 12/01/02

120

QC

Memo

0.00

Quality Control

0.00

130

HandFinish

Memo

0.00

Hand Finishing

7xØ m-l 12/04/05

Work Order ID 77848

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Page 3

Thursday, December 22, 2011 8:04:29 AM

Item ID: D4571-3 Accept ***N900040100*** Setup Start ***NS1***
 Revision ID: PRELIM Stop ***NS2***
 Item Name: Cover
 Start Date: 12/23/2011 Start Qty: 3.00 ***3*** Cust Item ID:
 Required Date: 12/29/2011 Req'd Qty: 3.00 ***3*** Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
140 *140* Powdercoat Powder Coating	Fire Red(Ref:4.3.5.10) per QSI005 4.3	0.00							
<p>Memo 1=10 START TIME: 3200F OVEN TEMPERATURE: 1=40 FINISH TIME:</p>									
150 *150* Packaging Packaging	Identify as per.dwg & Stock Location: _____	0.00							
<p>Memo 50 12/01/12</p>									
160 *160* QC Quality Control	QC21 - Final Inspection - Work Order Release	0.00							
<p>Memo 12/1/16</p>									

POSITIVE RECALL

EFFECTIVE 11/22/12 AUTH

RELEASED 12-01-12 DATE 12-01-16

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D4571-3 PAR #: _____ Fault Category: Machining NCR: Yes No DQA AK Date: 12/1/17
12-1115 Resolution: No work Disposition: Rework QA: N/C Closed: CL Date: 12/1/17

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			
12/01/10	#150	During assembly it was found that the hinge holes were drilled in the wrong orientation to the Part. RC. LRA @ machining	S 12/01/10	-Drill holes in correct location + tap as per Dwg. Due to chipping at P/C strain all parts + re-powder coat as per Dwg.	<u>OK</u> 12/01/10 MM 12/01/10	S 12/01/10	S 12/01/10	S 12/01/10
				Start 10:30 Fin 11:10 50 min temp 320°F	M-L 12/01/12	S 12/01/17	S 12/01/10	S 12/01/10
				Play holes with				
				Accurate to P/C for 50 min. 12/01/12				

NOTE: Date & initial all entries

Picklist Print

Page 1

Thursday, December 22, 2011 8:04:29 AM

Work Order ID: 77848

Parent Item: D4571-3

Parent Item Name: Cover

Start Date: 12/23/2011

Required Date: 12/29/2011

Start Qty: 3.00

Required Qty: 3.00

Comments: IPP REV:A NEW ISSUE 11-12-21 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6B1.500X02.500 6061-T6 Bar 1.50 x 2.50		Purchased	No				f	87.4000		1.9263158			

Location

Loc Qty

Loc Code

MAT004

87.4

103069

12

107387

39.4

16742

36

4.5

56 11/22/28

DART AEROSPACE LTD		Work Order: 77848
Description: REGAL LOCK		Part Number: 4571-3
Inspection Dwg: 4571-3 Rev: PA1		Page 1 of 1

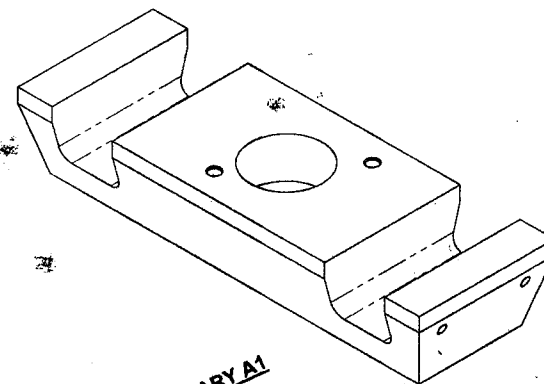
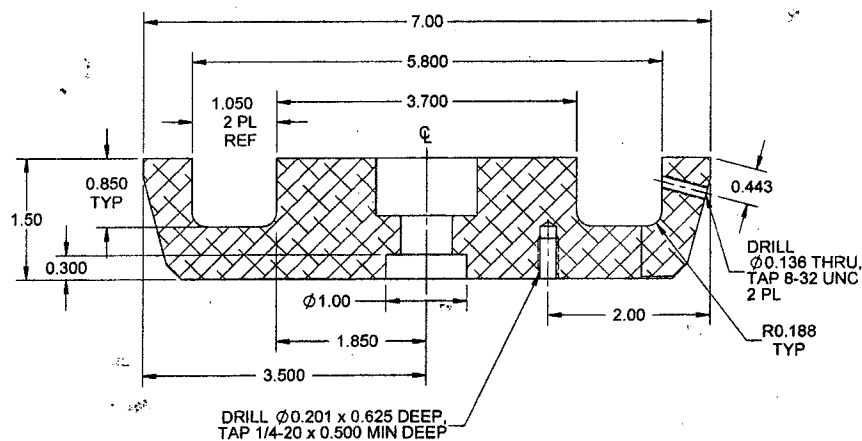
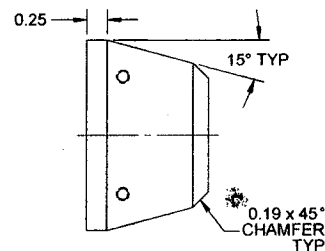
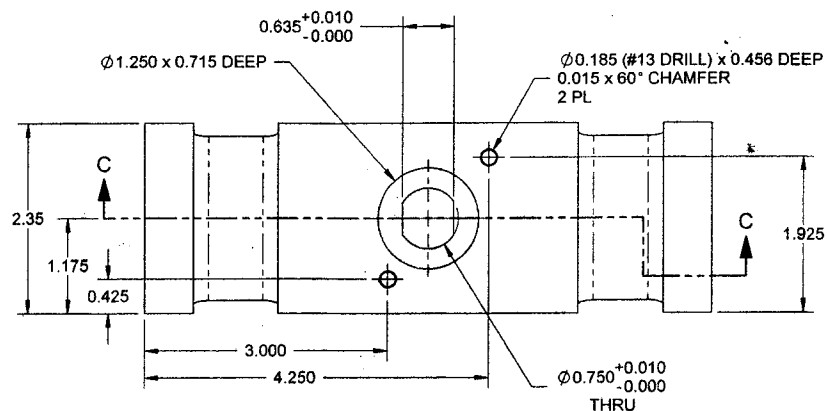
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
2.35	$\pm .03$	2.352	✓		Dial Caliper	15608
1.175	$\pm .01$	1.176	✓			
3.000	$\pm .01$	3.002	✓			
4.250	$\pm .01$	4.252	✓			
.425	$\pm .01$.425	✓			
1.925	$\pm .01$	1.925	✓			
$\phi .750$	$\begin{matrix} +.01 \\ -.00 \end{matrix}$.752	✓			
$\phi .635$	$\begin{matrix} +.01 \\ -.00 \end{matrix}$.640	✓			
$\phi .185$	$\begin{matrix} +.005 \\ -.001 \end{matrix}$.185	✓			
.250 .250	$\pm .03$.225	✓			
.850	$\pm .01$.852	✓			
1.50	$\pm .03$	1.500	✓			
.300	$\pm .01$.300	✓			
3.500	$\pm .01$	3.502	✓			
1.850	$\pm .01$	1.850	✓			
$\phi 1.00$	$\begin{matrix} +.01 \\ -.001 \end{matrix}$	1.000	✓			
2.00	$\pm .03$	2.006	✓			
12.188	$\pm .01$.188	✓			
.442	$\pm .01$.450	✓			
7.00	$\pm .03$	7.002	✓			
3.700	$\pm .010$	3.702	✓			
5.900	$\pm .01$	5.798	✓			
1.050	$\pm .01$	1.048	✓			

Measured by: <i>gk / h.a</i>	Audited by: <i>aml</i>	Preliminary Approval:
Date: 11/02/27	Date: 12/01/03	Date:

Rev	Date	Change	Revised by	Approved
E	10.04.14	Added preliminary approval	KJ	

10.04.15



PRELIMINARY A1
11.12.21 (RP)

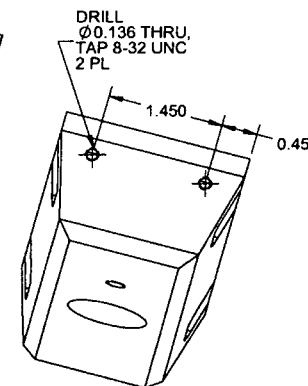
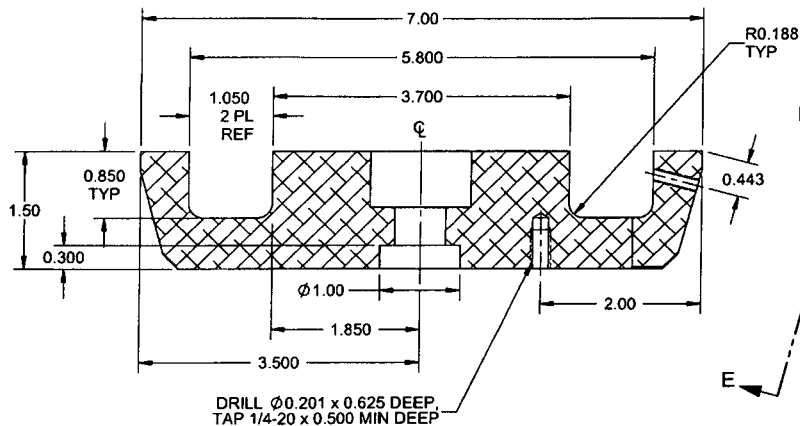
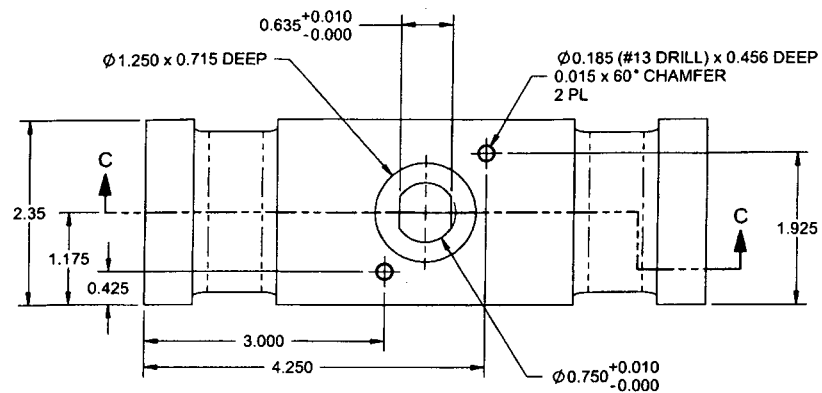
NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR ASTM B211 OR ASTM B221 REF. DART SPEC: M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1 POWDER COAT FIRE RED (4.3.5.10) PER DART QSI 005 4.3
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

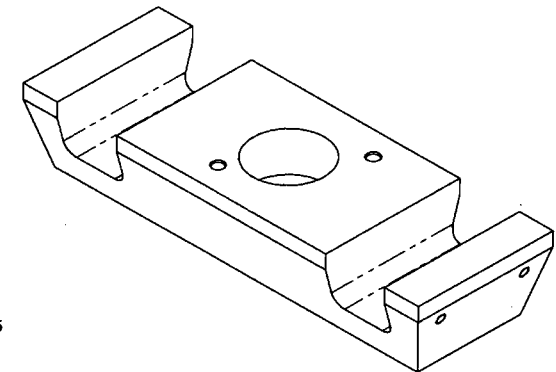
~~D4203-3 COVER~~

D4571-3

DESIGN	RP	DART AEROSPACE LTD	
DRAWN	RP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	MP	DRAWING NO.	REV. PA1
MFG. APPR.		D4571	SHEET 4 OF 4
APPROVED	<i>MP</i>	TITLE	SCALE
DE APPR.		PEDAL LOCK	NTS
DATE	11.12.21	COPYRIGHT © 2011 BY DART AEROSPACE LTD	
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VIEW E-E



NOTES:

- 1) MATERIAL: 6061-T6/T651 PER QQ-A-200/8 OR QQ-A-225/8 OR
ASTM B211 OR ASTM B221
REF. DART SPEC. M6061T6B
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
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- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.010
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) MASK INSIDE HOLES PRIOR TO FINISH

D4571-3 COVER

DESIGN	RP	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	RP		
CHECKED	MP	DRAWING NO. D4571	REV. A
MFG. APPR.			SHEET 4 OF 4
APPROVED		TITLE PEDAL LOCK	SCALE NTS
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DATE	12.01.06		

RELEASED
2012-01-10

77848